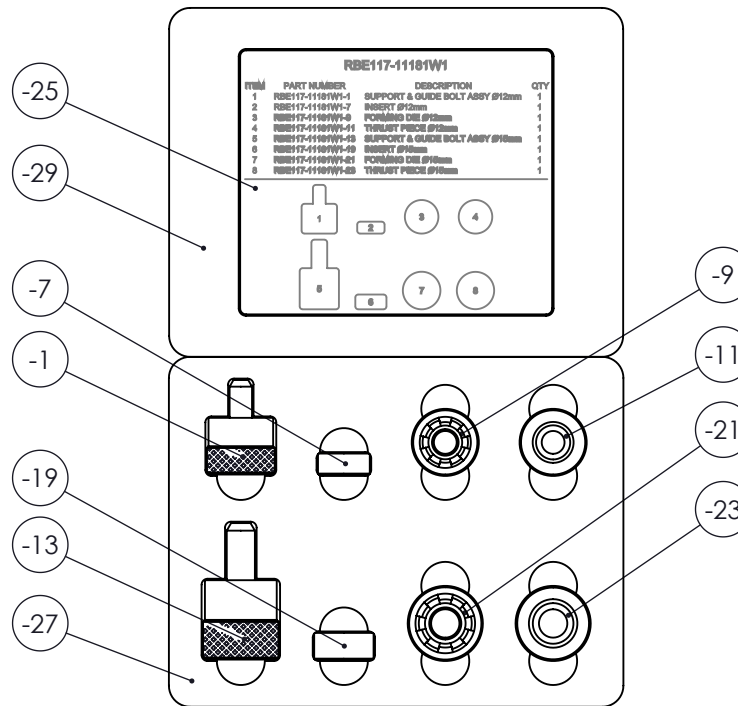


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	7/18/2017	DPD	JAG



#### NOTES:

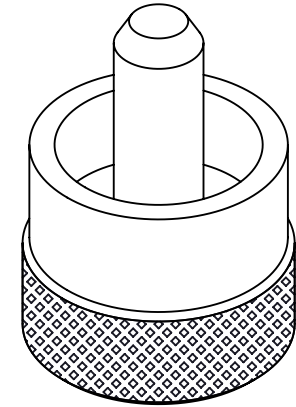
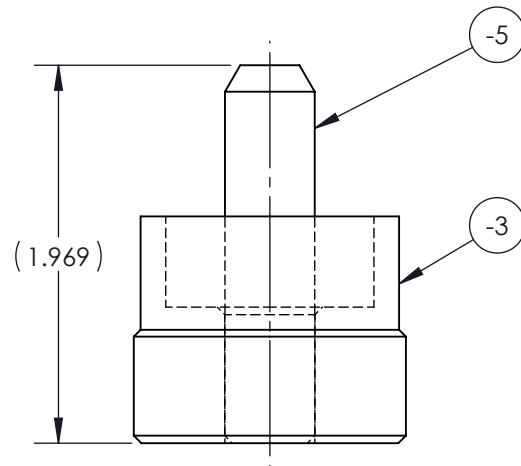
1. REF. AIRBUS T/N: 117-11181W1.
2. USAGE: FOR THE REMOVAL & INSTALLATION OF THE SPHERICAL BEARINGS LN9367GE15N1 & LN9367GE12N1 SUPPORTED BY CLAW RINGS.
3. USED ON MODELS:  
EC145, EC645, H145, H145M, BK117.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	SUPPORT & GUIDE BOLT ASSY Ø12mm			2
	1		-3		SUPPORT Ø12mm	O-1		3
	1		-5		GUIDE BOLT Ø12mm	O-1		4
			-7	1	INSERT Ø12mm	O-1		5
			-9	1	FORMING DIE Ø12mm	O-1		6
			-11	1	THRUST PIECE Ø12mm	O-1		7
X			-13	1	SUPPORT & GUIDE BOLT ASSY Ø15mm			8
1			-15		SUPPORT Ø15mm	O-1		9
1			-17		GUIDE BOLT Ø15mm	O-1		10
			-19	1	INSERT Ø15mm	O-1		11
			-21	1	FORMING DIE Ø15mm	O-1		12
			-23	1	THRUST PIECE Ø15mm	O-1		13
			-25	1	CONTENTS PLACARD	PLASTIC		14
		B/O	-27	1	BOTTOM FOAM	ETHAFOAM 220, BLACK	2.90 X 7.29 X 9.47 (CASE SOLUTIONS)	15
		B/O	-29	1	TOP FOAM	ETHAFOAM 220, BLACK	1.16 X 7.27 X 9.46 (CASE SOLUTIONS)	16
		B/O	-31	1	CASE	PLASTIC	PELICAN #APP-1200-E	N/S
		B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S
ASSY -13	ASSY -1							

		<b>TITLE</b> MAIN ROTOR DRIVE MOUNTING TOOL	
<b>DWG NO.</b> RBE117-11181W1		<b>REV</b> 1	
<b>MAT'L</b> HEAT TREAT FINISH SPEC		<b>UNLESS OTHERWISE SPECIFIED</b> DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°	
<b>DRAWN BY:</b> DD 06/29/2017 <b>CHECKED:</b> RJC 06/30/2017 <b>OPPS APPR:</b> AA 07/10/2017 <b>QA APPR:</b> JL 07/10/2017 <b>APPROVED:</b> JAG 07/19/2017		<b>1. BREAK ALL SHARP EDGES</b> .015 x 45° OR .015R <b>2. DIMENSIONAL LIMITS APPLY AFTER PLATING</b> <b>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</b>	
<b>SCALE</b> 1:4 <b>DATE</b> 6/29/2017		<b>USED ON MODEL</b> SEE NOTE 3	
		<b>SHEET 1 OF 16</b>	

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REVISIONS				
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				APPROVED

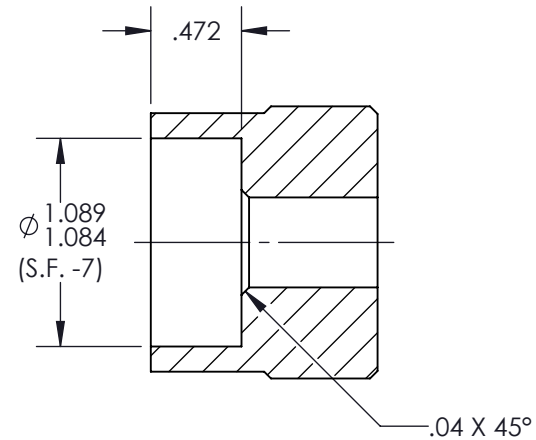
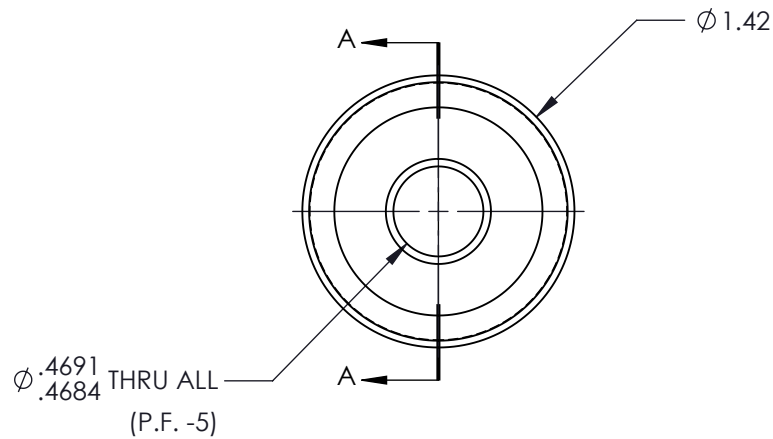


(-1)  
SUPPORT & GUIDE BOLT ASSY Ø12mm

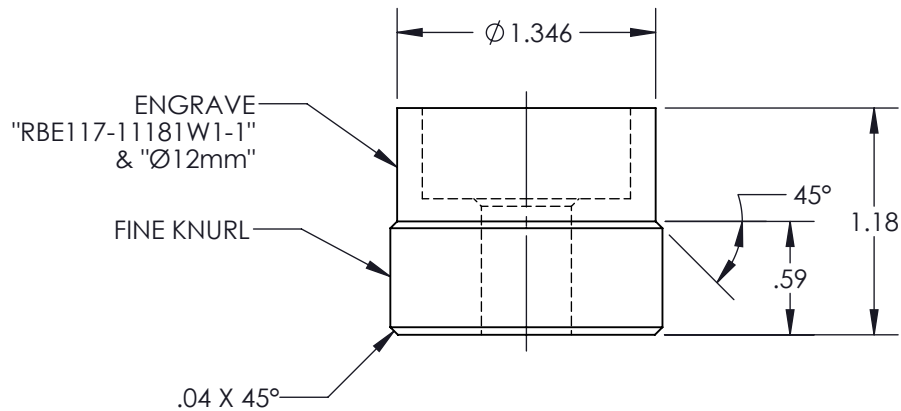
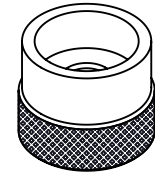
<b>DART AEROSPACE</b>	
TITLE MAIN ROTOR DRIVE MOUNTING TOOL	
DWG NO. RBE117-11181W1-1	REV 1
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
DRAWN BY: DD 06/29/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 06/30/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/10/2017	USED ON MODEL
APPROVED: JAG 07/19/2017	SEE NOTE 3, SHEET 1
SCALE 1:1	DATE 6/29/2017
SHEET 2 OF 16	

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				APPROVED



SECTION A-A



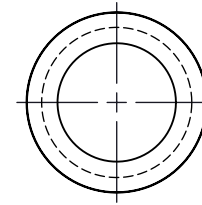
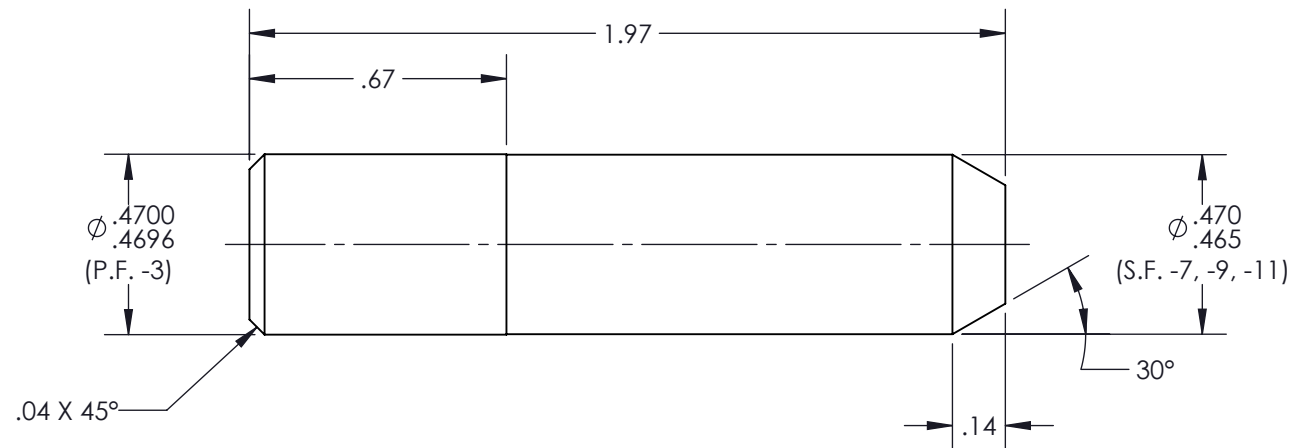
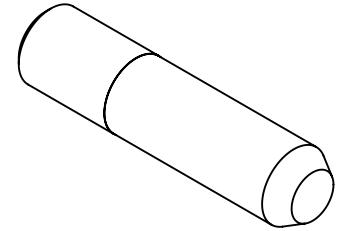
(3)

SUPPORT  $\phi 12\text{mm}$

<b>DART AEROSPACE</b>	
TITLE MAIN ROTOR DRIVE MOUNTING TOOL	
DWG NO. RBE117-11181W1-3	REV 1
MAT'L O-1	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT RC 50-55	.XXX $\pm$ .005 FRACTIONS $\pm$ 1/8
FINISH BLACK OXIDE	.XX $\pm$ .01 ANGLES $\pm$ .5°
SPEC QMSI-6.2.2, B.O. REV D	.X $\pm$ .1 SURFACES = 125°
DRAWN BY: DD 06/29/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 06/30/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/10/2017	USED ON MODEL
APPROVED: JAG 07/19/2017	SEE NOTE 3, SHEET 1
SCALE 1:1	DATE 6/29/2017
SHEET 3 OF 16	

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REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



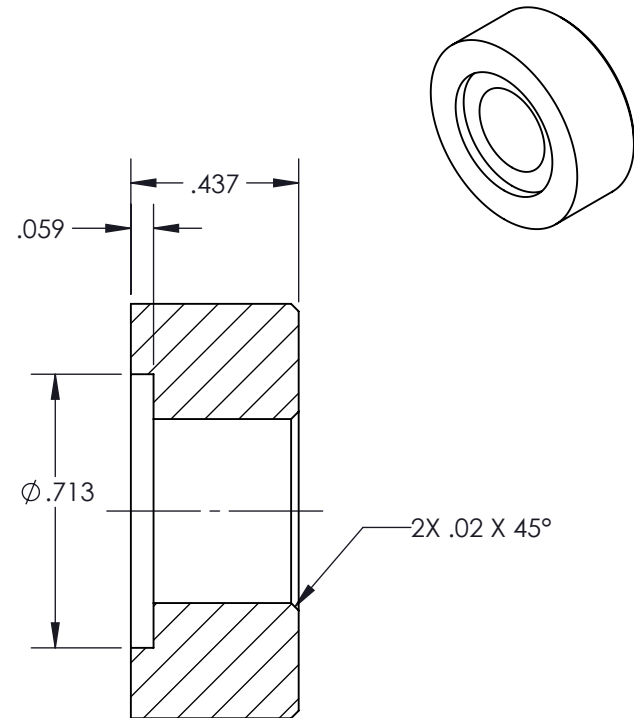
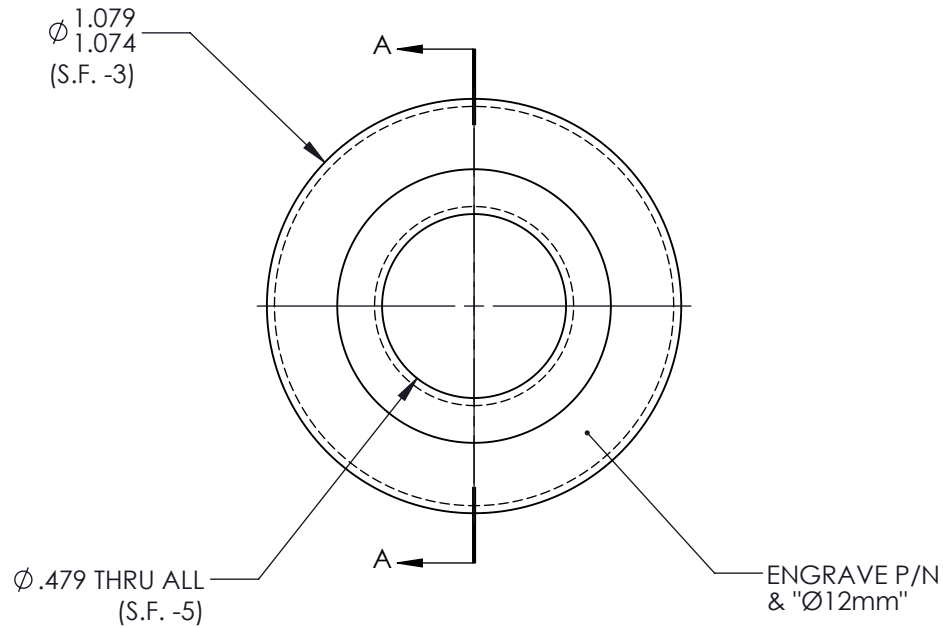
(-5)

GUIDE BOLT Ø12mm

<b>DART AEROSPACE</b>	
TITLE MAIN ROTOR DRIVE MOUNTING TOOL	
DWG NO. RBE117-11181W1-5	REV 1
MAT'L O-1	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 50-55	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
DRAWN BY: DD 06/29/2017	.X ± .1 SURFACES = 125
CHECKED: RJC 06/30/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 07/10/2017	.015 x 45° OR .015R
QA APPR: JL 07/10/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
APPROVED: JAG 07/19/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 2:1	USED ON MODEL
DATE 6/29/2017	SEE NOTE 3, SHEET 1
	SHEET 4 OF 16

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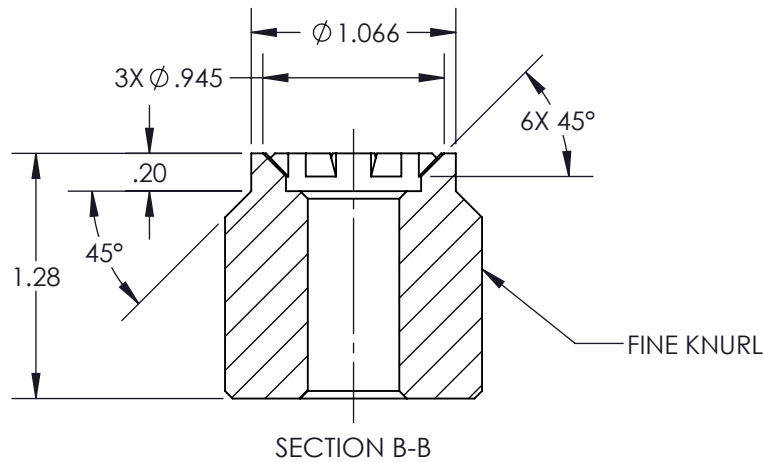
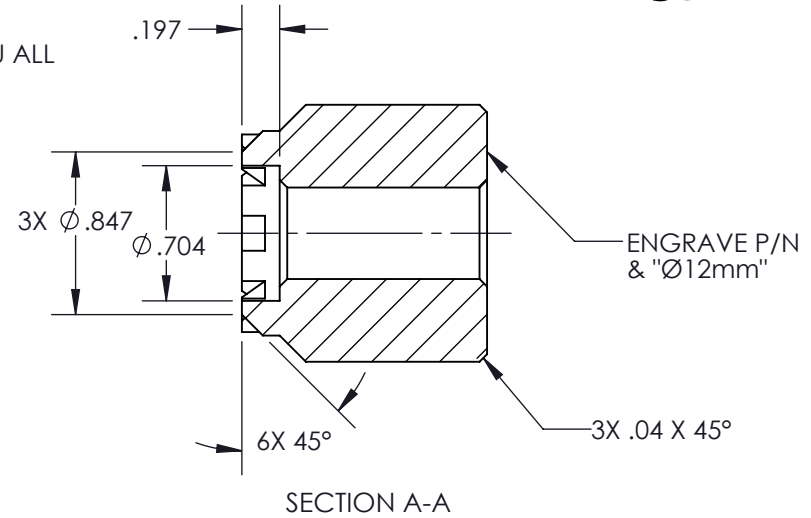
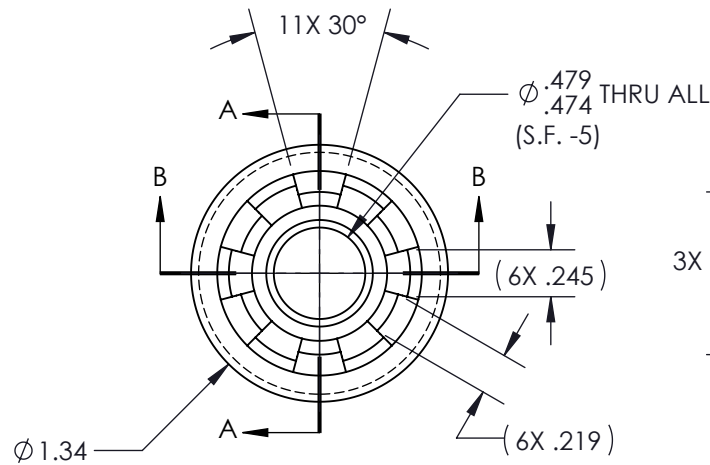
SECTION A-A

(-7)  
INSERT Ø12mm

<b>DART AEROSPACE</b>	
TITLE MAIN ROTOR DRIVE MOUNTING TOOL	
DWG NO. RBE117-11181W1-7	REV 1
MAT'L O-1	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT RC 50-55	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± .5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125°
DRAWN BY: DD 06/29/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 06/30/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/10/2017	USED ON MODEL
APPROVED: JAG 07/19/2017	SEE NOTE 3, SHEET 1
SCALE 2:1	DATE 6/29/2017
SHEET 5 OF 16	

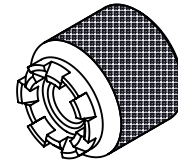
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				APPROVED



(9)

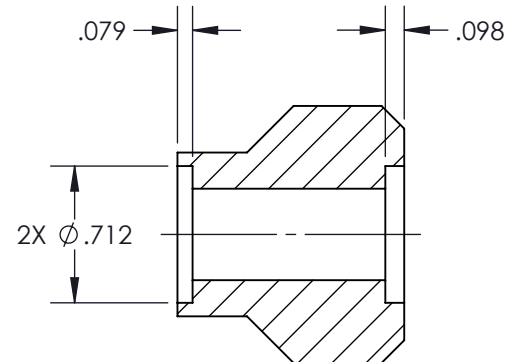
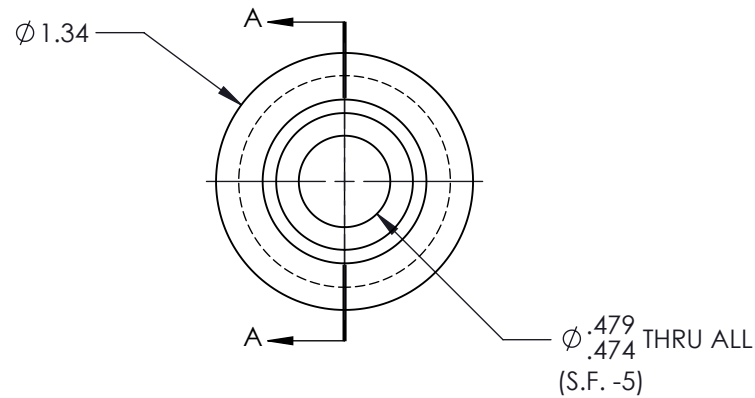
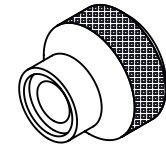
FORMING DIE Ø12mm



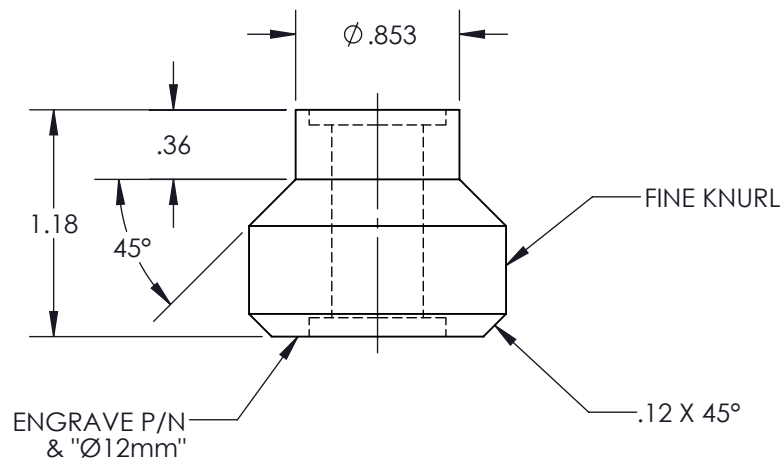
DART AEROSPACE			
TITLE		MAIN ROTOR DRIVE MOUNTING TOOL	
DWG NO.		RBE117-11181W1-9	REV 1
MAT'L	Q-1	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125° ✓	
HEAT TREAT	RC 50-55		
FINISH	BLACK OXIDE		
SPEC	QMSI-6.2.2, B.O. REV D		
DRAWN BY:	DD 06/29/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED:	RJC 06/30/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR:	AA 07/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR:	JL 07/10/2017	USED ON MODEL	
APPROVED:	JAG 07/19/2017	SEE NOTE 3, SHEET 1	
SCALE	1:1	DATE	6/29/2017
		SHEET 6 OF 16	

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				APPROVED



SECTION A-A



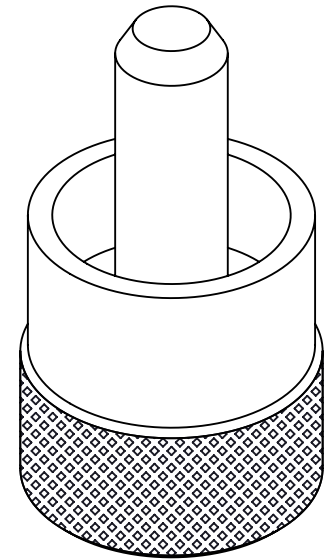
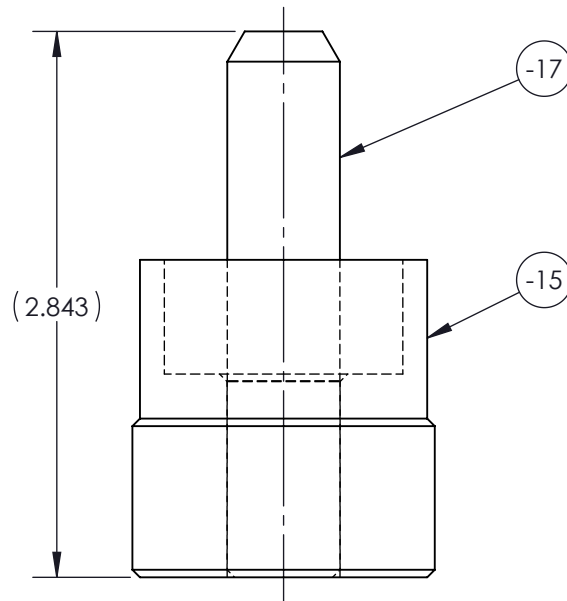
(11)

THRUST PIECE Ø12mm

<b>DART AEROSPACE</b>	
TITLE MAIN ROTOR DRIVE MOUNTING TOOL	
DWG NO. RBE117-11181W1-11	REV 1
MAT'L O-1	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 50-55	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
DRAWN BY: DD 06/29/2017	.X ± .1 SURFACES = 125
CHECKED: RJC 06/30/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 07/10/2017	.015 x 45° OR .015R
QA APPR: JL 07/10/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 07/19/2017	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 6/29/2017	USED ON MODEL
SHEET 7 OF 16	SEE NOTE 3, SHEET 1

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				APPROVED



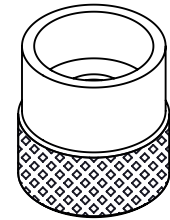
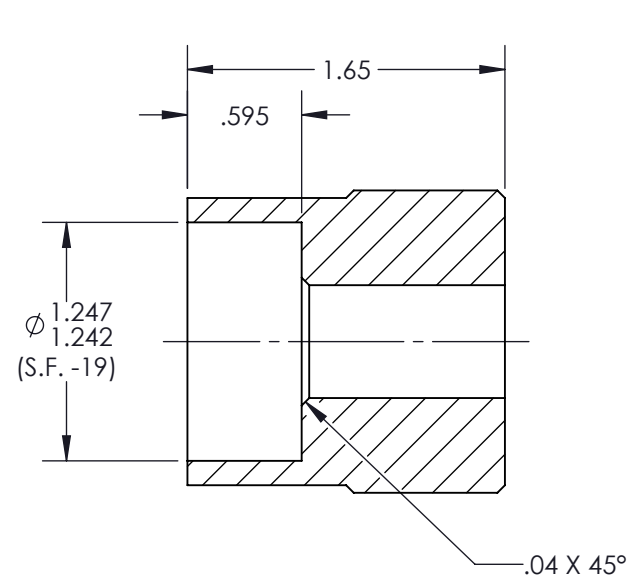
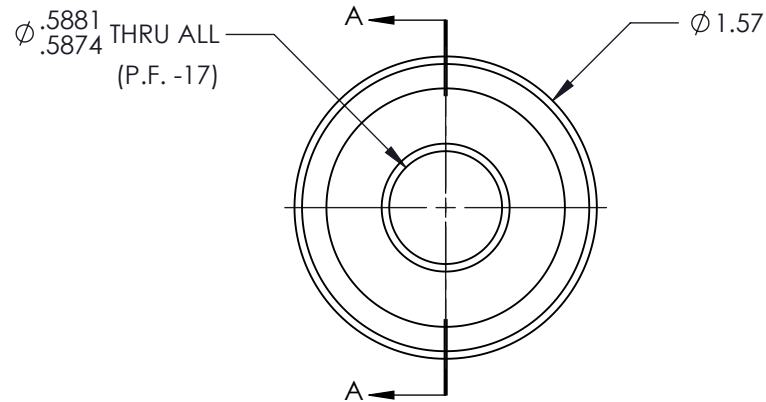
SUPPORT & GUIDE BOLT ASSY Ø15mm

<b>DART AEROSPACE</b>	
TITLE MAIN ROTOR DRIVE MOUNTING TOOL	
DWG NO. RBE117-11181W1-13	REV 1
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: DD 06/29/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 06/30/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/10/2017	USED ON MODEL
APPROVED: JAG 07/19/2017	SEE NOTE 3, SHEET 1
SCALE 1:1	DATE 6/29/2017
SHEET 8 OF 16	

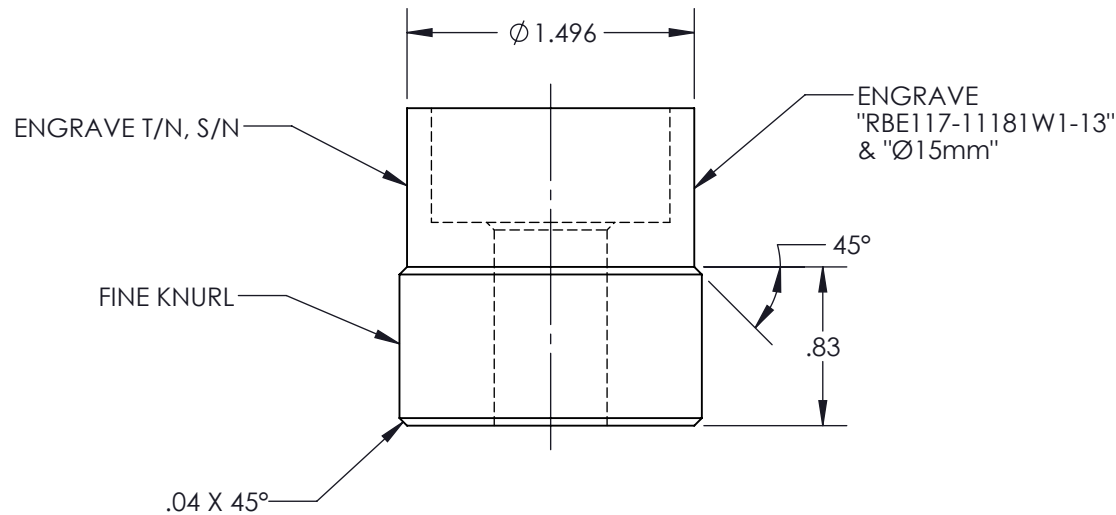


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				APPROVED



SECTION A-A



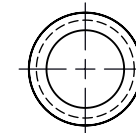
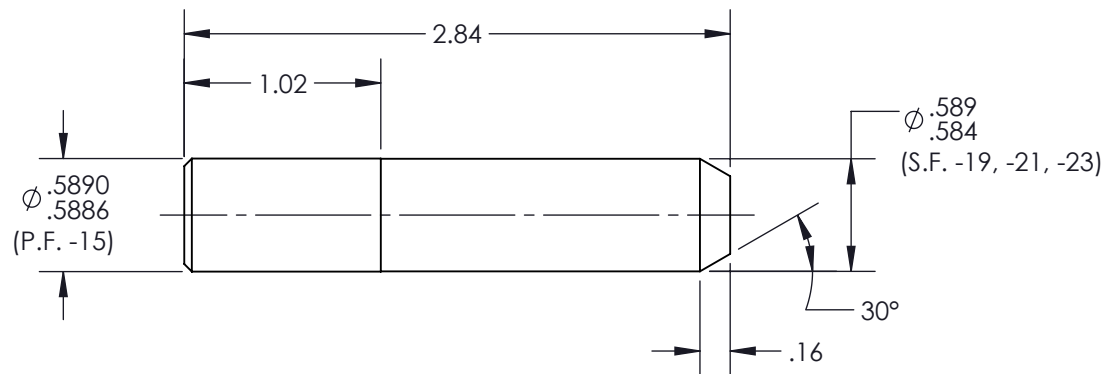
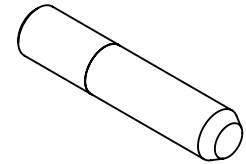
(-15)

SUPPORT Ø15mm

<b>DART AEROSPACE</b>	
TITLE <b>MAIN ROTOR DRIVE MOUNTING TOOL</b>	
DWG NO. <b>RBE117-11181W1-15</b>	REV <b>1</b>
MAT'L O-1	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 50-55	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
DRAWN BY: DD 06/29/2017	.X ± .1 SURFACES = 125
CHECKED: RJC 06/30/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 07/10/2017	.015 x 45° OR .015R
QA APPR: JL 07/10/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 07/19/2017	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 6/29/2017	USED ON MODEL
SHEET 9 OF 16	SEE NOTE 3, SHEET 1

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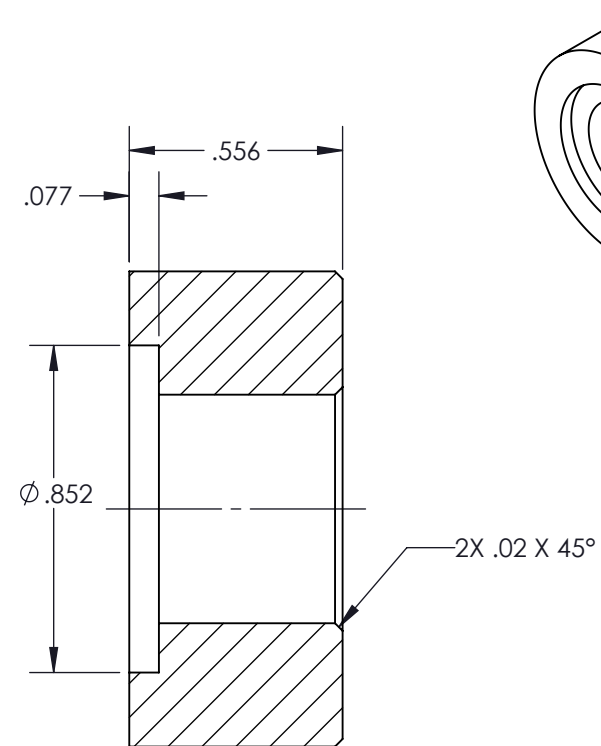
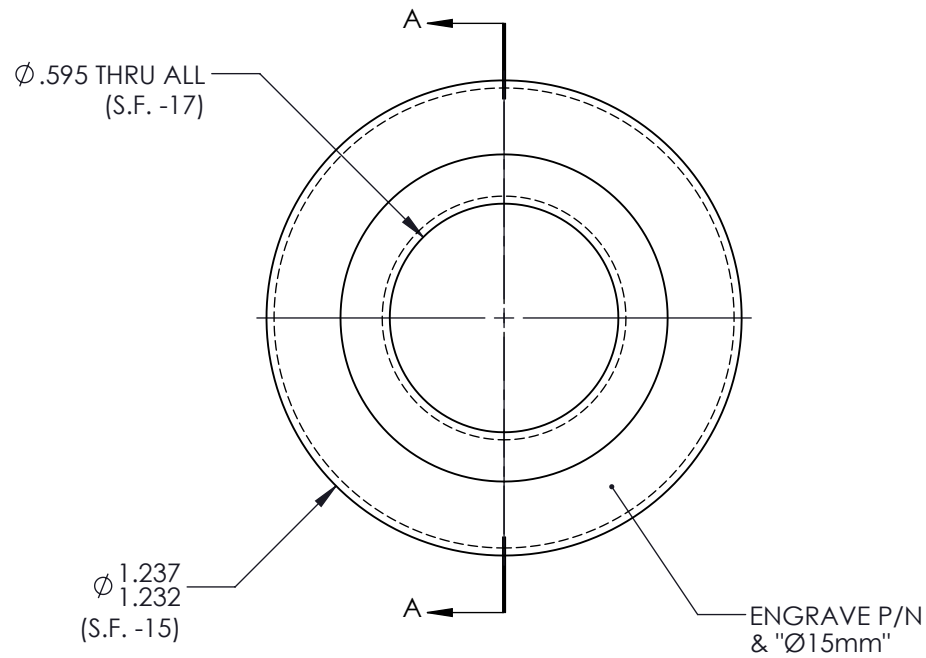
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GUIDE BOLT Ø15mm

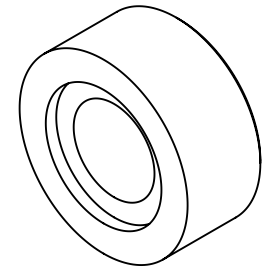
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TITLE MAIN ROTOR DRIVE MOUNTING TOOL	
DWG NO. RBE117-11181W1-17	REV 1
MAT'L O-1	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 50-55	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
DRAWN BY: DD 06/29/2017	.X ± .1 SURFACES = 125°
CHECKED: RJC 06/30/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 07/10/2017	.015 x 45° OR .015R
QA APPR: JL 07/10/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 07/19/2017	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 6/29/2017	USED ON MODEL
SHEET 10 OF 16	SEE NOTE 3, SHEET 1

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



SECTION A-A



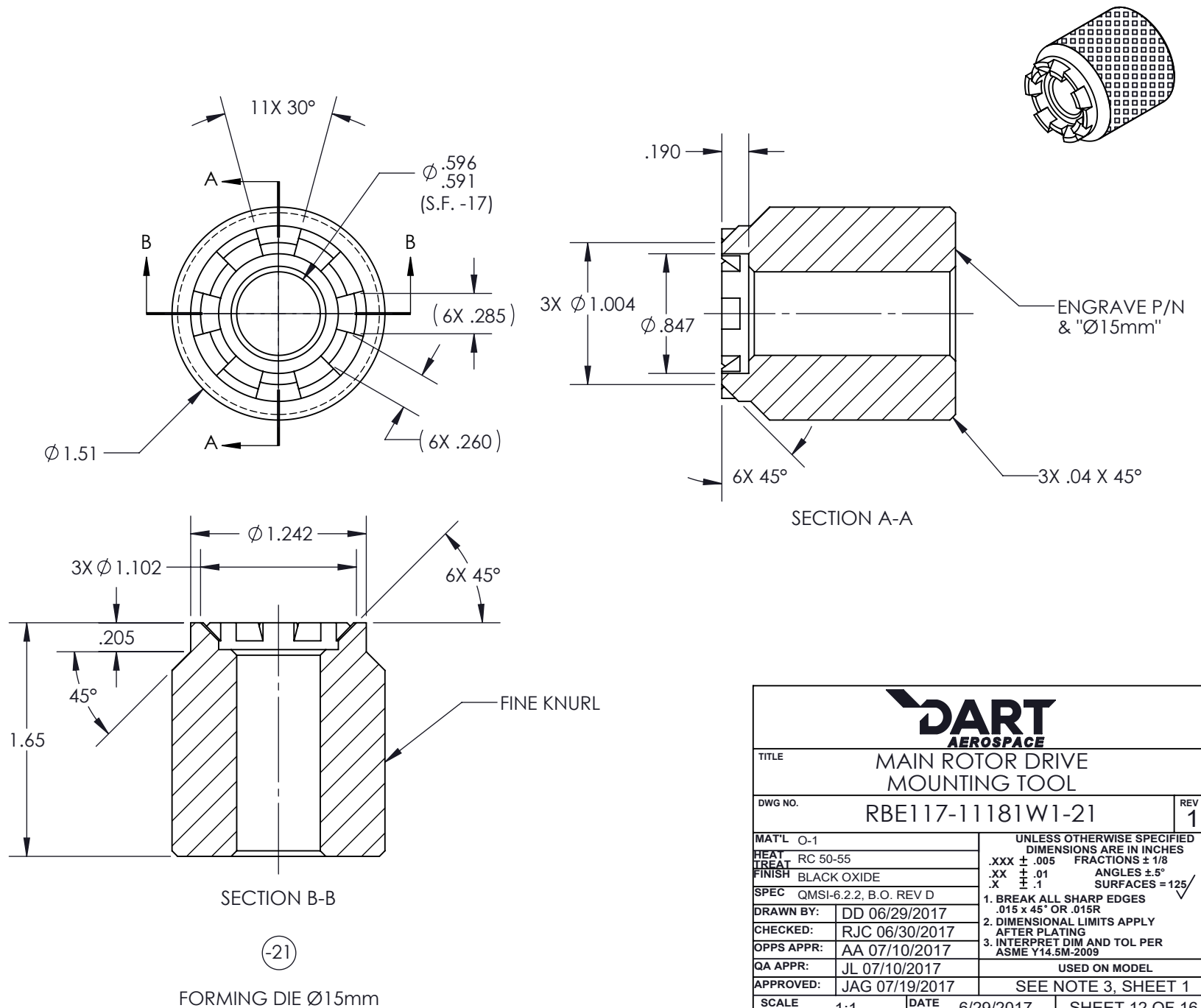
(-19)

INSERT Ø15mm

<b>DART AEROSPACE</b>	
TITLE MAIN ROTOR DRIVE MOUNTING TOOL	
DWG NO. RBE117-11181W1-19	REV 1
MAT'L O-1	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 50-55	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± .5°
DRAWN BY: DD 06/29/2017	.X ± .1 SURFACES = 125
CHECKED: RJC 06/30/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 07/10/2017	.015 x 45° OR .015R
QA APPR: JL 07/10/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 07/19/2017	AFTER PLATING
SCALE 2:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 6/29/2017	USED ON MODEL
SHEET 11 OF 16	SEE NOTE 3, SHEET 1

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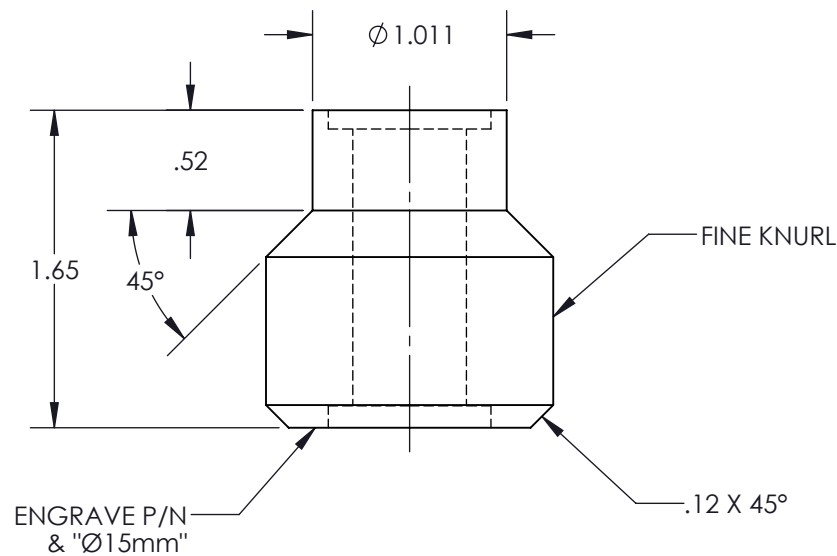
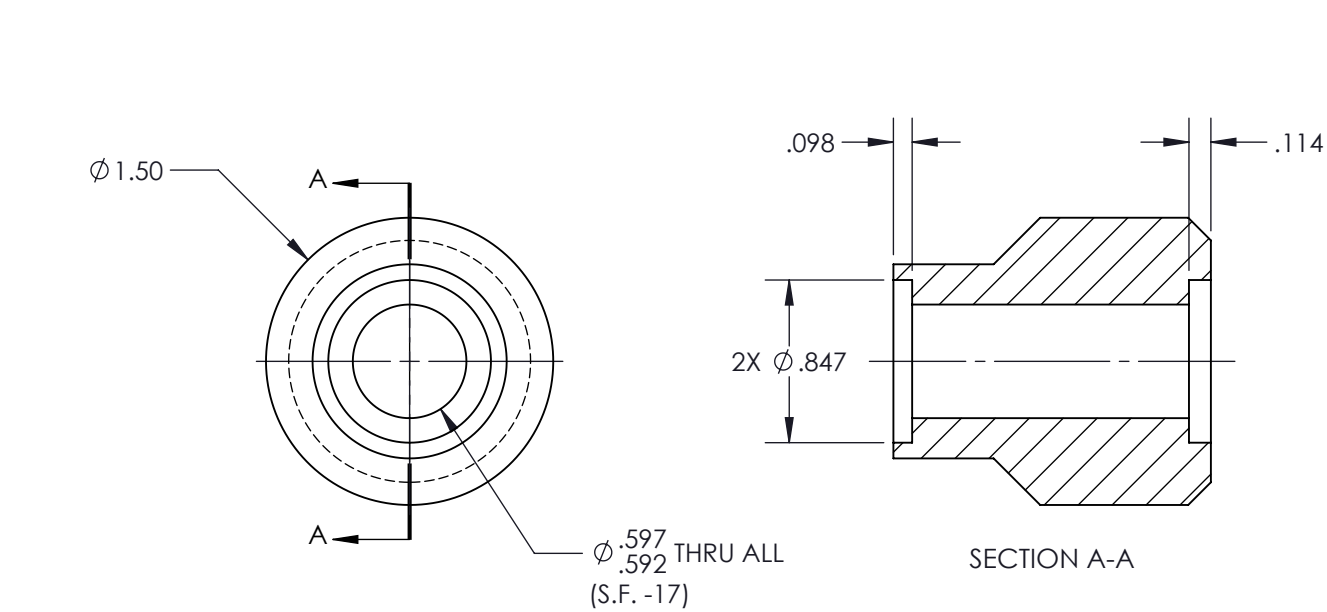
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



TITLE		MAIN ROTOR DRIVE MOUNTING TOOL	
DWG NO.		RBE117-11181W1-21	REV 1
MAT'L	Q-1	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°	
HEAT TREAT	RC 50-55		
FINISH	BLACK OXIDE		
SPEC	QMSI-6.2.2, B.O. REV D		
DRAWN BY:	DD 06/29/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
CHECKED:	RJC 06/30/2017		
OPPS APPR:	AA 07/10/2017		
QA APPR:	JL 07/10/2017		
APPROVED:	JAG 07/19/2017	USED ON MODEL	
SCALE	1:1	DATE	6/29/2017
		SHEET 12 OF 16	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

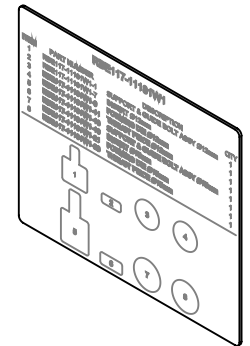
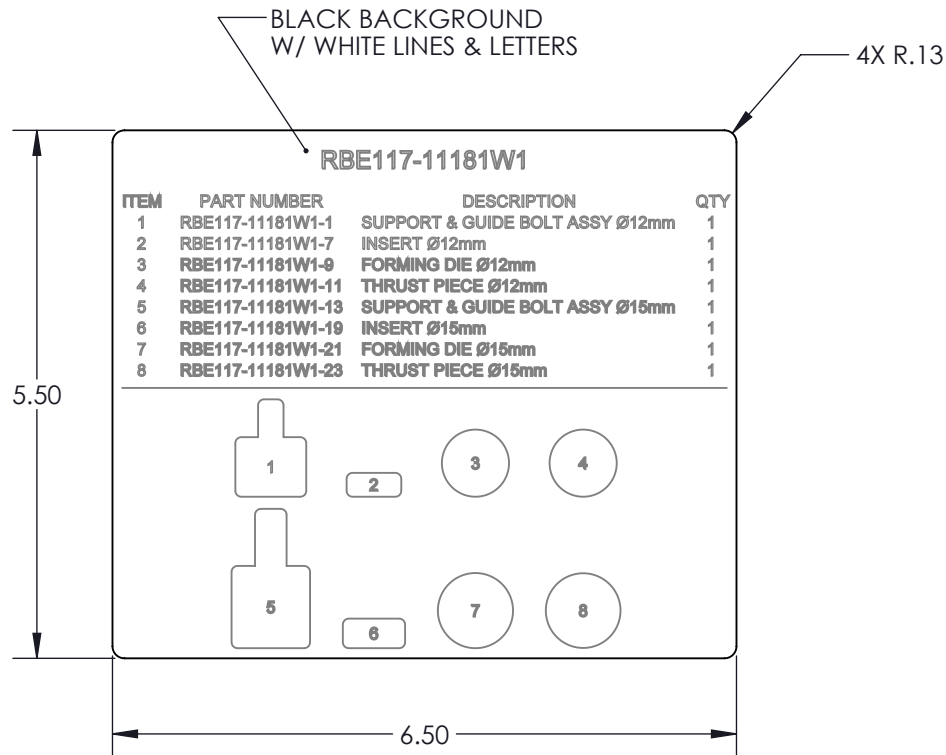


(-23)

<b>DART AEROSPACE</b>	
TITLE MAIN ROTOR DRIVE MOUNTING TOOL	
DWG NO. RBE117-11181W1-23	REV 1
MAT'L O-1	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 50-55	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± .5°
DRAWN BY: DD 06/29/2017	.X ± .1 SURFACES = 125
CHECKED: RJC 06/30/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 07/10/2017	.015 x 45° OR .015R
QA APPR: JL 07/10/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 07/19/2017	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 6/29/2017	USED ON MODEL
SHEET 13 OF 16	SEE NOTE 3, SHEET 1

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REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED



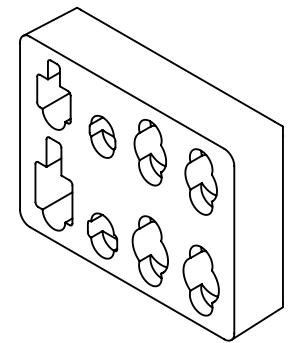
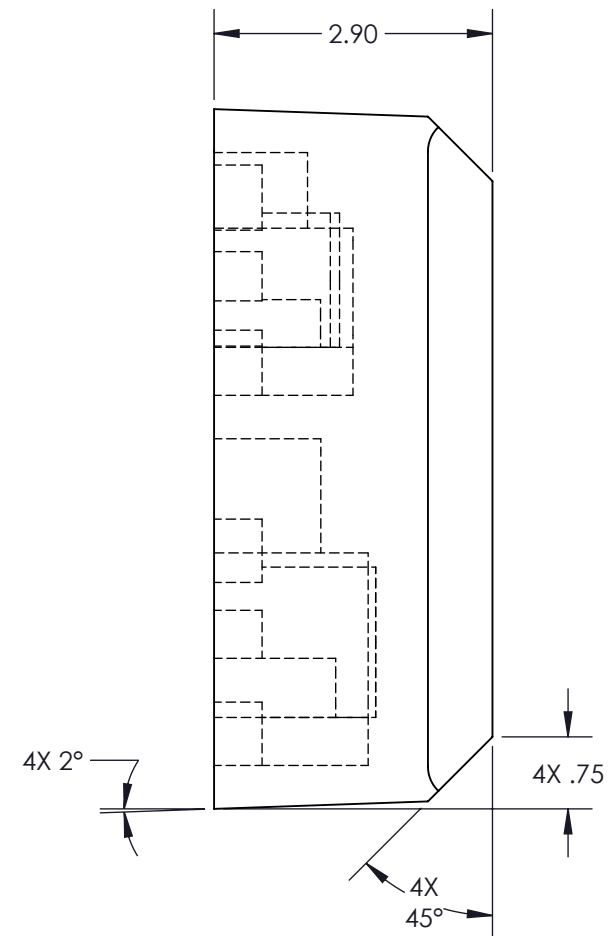
NOTE:  
USE PDF.

(-25)


CONTENTS PLACARD

<b>DART AEROSPACE</b>	
TITLE MAIN ROTOR DRIVE MOUNTING TOOL	
DWG NO. RBE117-11181W1-25	REV 1
MAT'L PLASTIC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DD 06/29/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 06/30/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/10/2017	USED ON MODEL
APPROVED: JAG 07/19/2017	SEE NOTE 3, SHEET 1
SCALE 1:2	DATE 6/29/2017 SHEET 14 OF 16

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED

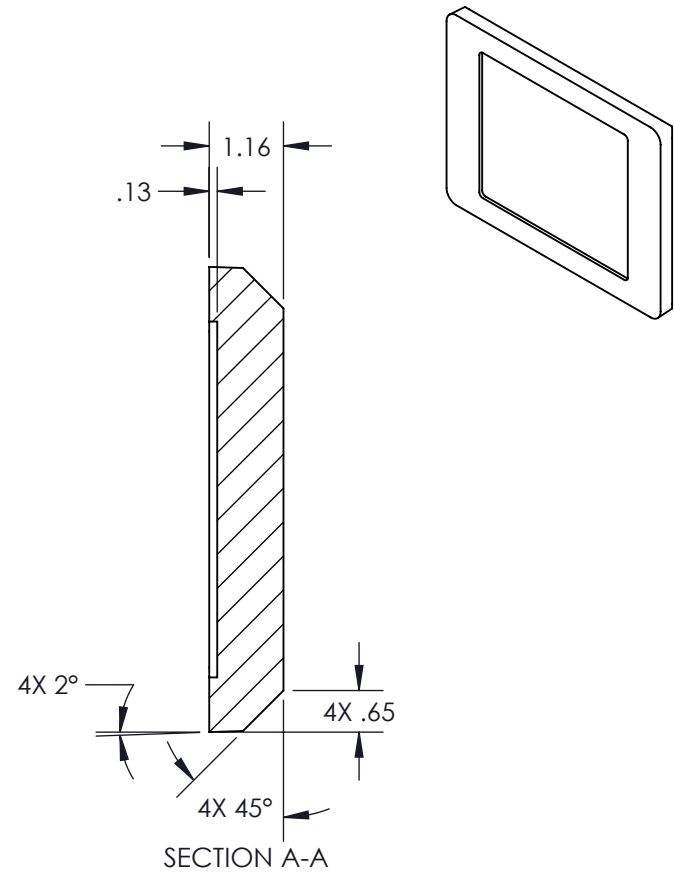
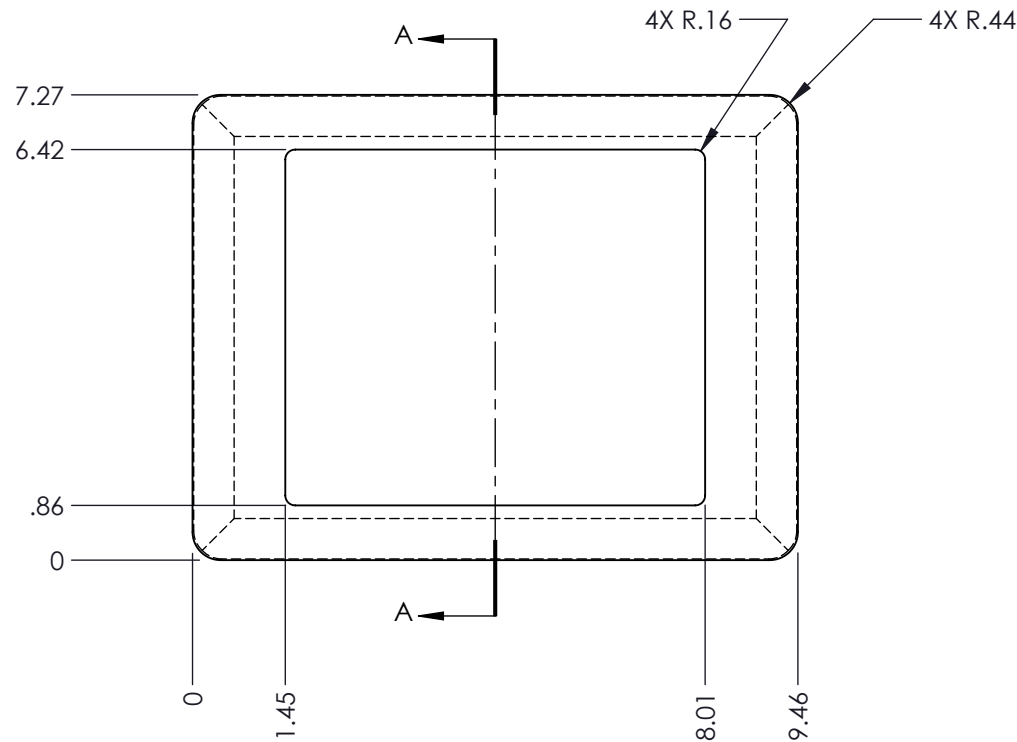


BOTTOM FOAM

		
TITLE MAIN ROTOR DRIVE MOUNTING TOOL		
DWG NO. RBE117-11181W1-27		REV 1
MAT'L ETHAFOAM 220, BLACK		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ±1° .X ± .1 SURFACES = 125/√
HEAT TREAT		
FINISH		
SPEC		
DRAWN BY: DD 06/29/2017		
CHECKED: RJC 06/30/2017		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
OPPTS APPR: AA 07/10/2017		2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: JLG 07/10/2017		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: JAG 07/19/2017		USED ON MODEL SEE NOTE 3, SHEET 1
SCALE 1:2	DATE 6/29/2017	SHEET 15 OF 16

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				APPROVED



(-29)  
TOP FOAM

<b>DART AEROSPACE</b>	
TITLE MAIN ROTOR DRIVE MOUNTING TOOL	
DWG NO. RBE117-11181W1-29	REV 1
MAT'L ETHAFOAM 220, BLACK	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT FINISH	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: DD 06/29/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 06/30/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/10/2017	USED ON MODEL
APPROVED: JAG 07/19/2017	SEE NOTE 3, SHEET 1
SCALE 1:3	DATE 6/29/2017
SHEET 16 OF 16	